

Thursday, December 15, 2016 1:33:59 PM

Ship JAN 6

Item ID: D3822-7KIV

Accept

N9000401 00

Setup Start *NS1*

Stop *NS2*

Item Name: Vertical Tunnel, Lower, Ivory

Start Date: 12/12/2016 **Start Qty:** 1.00

1

Cust Item ID:

Required Date: 12/15/2016 **Req'd Qty:** 1.00

1

Customer:

Reference:

Approvals: _____ **Process Plan:** _____ **Date:** DEC 15 2016 **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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D3822 Rev C

100

0.00

100

HandThermo

Memo

0.00

Hand Finishing Thermoforming

1-Cut Sheet to required Blank size

DAS
07
9-89

16/12/20

105

0.00

105

HandThermo

Dry Material

0.00

Hand Finishing Thermoforming

Memo

Dry Sheet as per QSI022 KYDEX

DAS
07
9-89

16/17/20

Temp: 150 deg. F DEC 20 2016

5:00 PM

Time IN: _____

Time OUT: _____

Per.....

154596

Thursday, December 15, 2016 1:33:59 PM

N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 12/12/2016 **Start Qty:** 1.00 ***1***

Required Date: 12/15/2016 **Req'd Qty:** 1.00 ***1***

Reference:

Run Start *NR1*

Approvals: _____ **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

[illegible]

Work Order ID 154596***154596***

Page 3

Thursday, December 15, 2016 1:33:59 PM

Item ID: D3822-7KIV Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Vertical Tunnel, Lower, Ivory
Start Date: 12/12/2016 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 12/15/2016 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	QC2- Inspect parts off machine FAI/FAIB	0.00							DAS 07 9-89
150									
QC	Memo	0.00							
Quality Control	Complete FAI document								16/12/22
160	QC5- Inspect part completeness to step on W/O	0.00							DAS 9 9-89
160									
QC	Memo	0.00							
Quality Control									
170	Identify as per dwg & Stock Location: <u>PK</u>	0.00							
170									
Packaging	Memo	0.00							
Packaging									JAN 03 2017 6 9-89

Work Order ID 154596***154596***

Page 4

Thursday, December 15, 2016 1:33:59 PM

Item ID: D3822-7KIV Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Vertical Tunnel, Lower, Ivory
Start Date: 12/12/2016 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 12/15/2016 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	QC21 - Final Inspection - Work Order Release	0.00					DAS 21 9-89		JAN 0 6 2017
180 QC	Memo	0.02							
Quality Control								DAS 21 9-89	JAN 0 3 2017

Picklist Print

Thursday, December 15, 2016 1:33:59 PM

Page 1

Work Order ID: 154596

154596

Parent Item: D3822-7KIV

D3822-7KIV

Parent Item Name: Vertical Tunnel, Lower, Ivory

Start Date: 12/12/2016

Required Date: 12/15/2016

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP RevA: New issue DD verified by:EC
Add Step 105 Dry Material 10/04/21 DL

Ipp Rev. B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MKYD6185S.080-P3-62015		Purchased		No		100	sf	1,738.890	2.16	2.161081			DAS 07 9-89

MKYD6185S 080-P3-62015

Kydex Ivory (52"x96"-.080)

Location	Loc Qty	Loc Code
SHED	728	
m129761	347	
m130671	381	
therm	1010.89	
121755	13.44	
124462	997.45	

16/12/20

2.17 sg H

DART AEROSPACE LTD		Work Order: 154596
Description: Vertical Tunnel, Lower		Part Number: D3822-7KIV/KGY
Inspection Dwg: D3822	Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than "	✓			
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by:	DAS 07 9-89	Date: 16/13/20
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TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.20 - 0.15	Min	0.25"	✓			
0.060	Min	0.065"	✓			
2.0	Min	2.04"	✓			
17.0	Min	17.6"	✓			
0.4	Min	0.55"	✓			
0.2 N/A	Min N/A					
5.9	+/-0.100	5.8"	✓			

Measured by:	DAS 07 9-89	Date: 16/12/22
Audited by:		Date: 16-12-22
Preliminary Approval:		Date:

Rev	Date	Change	Revised by	Approved
A	09.07.29	New Issue	KJ	
B	10.11.12	Dimensions added	KJ	

8 7 6 5 4 3 2 1

D

C

B

A

MIN THICKNESS 0.040 MIN THICKNESS 0.040

6

0.20
0.15
2.0
0.4 REF
0.3 REF
0.3 REF

5.9
H
17.00 MIN
TEXTURED SIDE
H^{B1-6}

D

C

B

A

D3822-7 VERTICAL TUNNEL, LOWER
(BELL 206 A/B)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 154596/MLJ

SECTION H-H B3-6

RELEASED
69/05/22-17P

NOTES:

- 1) MATERIAL: SEE TABLE
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N (SEE TABLE) WITH VIBRATING STYLUS
- 7) WEIGHT: 0.36 lbs
- 8) TOOLING: THERMOFORM PER MOLD DT9396 PER DART QSI 022
- 9) MINIMUM THICKNESS: 0.060" UNLESS OTHERWISE NOTED



PART NUMBER	DESCRIPTION
D3822-7KIV	KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, IVORY #62015 (MKYD6185S.080-P3-62015)
D3822-7KGY	KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, STEEL GRAY #52068 (MKYD6185S.080-P3-52068)

DESIGN	84	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	24	DRAWING NO.	REV. C
CHECKED		D3822	SHEET 6 OF 6
MFG. APPR.		TITLE	SCALE
APPROVED		VERTICAL TUNNEL (BELL 206 A/B)	NTS
DE APPR.		COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DATE	09.05.05		

8 7 6 5 4 3 2 1